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Rush!!!

D3564-9

Job Sheet 194398



Part No: D3564-9

Job Qty: 12 pcs

Part Name: Wearplate Fwd



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/1/19

Job Tracking No:

Due Date: 5/22/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:A New Issue 07-03-08 ec IPP Rev:B As per Rev C 07-07-09 JLM IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		5/22/19	0.00	2.32	Waterjet - Flow		<i>05/19/2019</i>
120	QC 8	12 pcs		5/22/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		<i>DAS</i>
							QC 8 - 67		<i>JUN 04 2019 68</i>
							QC 8 - 1 (A)		<i>9-89</i>
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		<i>DAS</i>
130	Small Fab - Brake NC - B4B	12 pcs		5/22/19	0.00	0.64	Small Fab - Brake - 1 - B4B		<i>30</i>
							Small Fab - Brake - 2 - B4B		<i>9-89</i>
							Small Fab - Brake - 3 -		<i>JUN 05 2019</i>

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				B4B	
140 QC 5	12 pcs	5/22/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	EL
				QC 5 - 30	
				QC 5 - 40	
150 Automated Welding - B4B	12 pcs	5/22/19	0.00 4.80	Automated Welding - 1 - B4B	ML
160 QC 10	12 pcs	5/22/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	EL
				QC 10 - 58	
				QC 10 - 9	
170 QC 5	12 pcs	5/22/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	EL
				QC 5 - 30	
				QC 5 - 40	
180 Spray Paint - 2 - B4B	12 pcs	5/22/19	0.00 4.00	Spray Paint - 1 - B4B	AB 19-6-6
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
190 QC 5	12 pcs	5/22/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	

				QC 5 - 58	DAS
				QC 5 - 68	JUN 07 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
200	Packaging 3-1 - Stock - B4B	12 pcs	5/22/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
210	QC 21 - SA	12 pcs	5/22/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 120 - (QC8- Inspect parts - second check) Descriptions: 130 - (Form as per dwg) 140 - (QC5- Inspect part completeness to step on W/O) 150 - (Automated welding) 160 - (QC10- Inspect visual per QSI004- ground welds) 170 - (QC5- Inspect part completeness to step on W/O) 180 - TEXTURE COAT BATCH: 5184717 190 - (QC5- Inspect part completeness to step on W/O) 200 - (Identify as per dwg & Stock Location: FP02) 210 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M304S16GA	304/316 Sheet .063	16.9200 sf (1.41 ea)	100-Waterjet - Flow - 1	5159674	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	17	237	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	3.227inches $\pm$ 0.010	3.237 3.217		
2	Wearshoe	2.432inches $\pm$ 0.010	2.442 2.422		
3	Wearshoe	2.500inches $\pm$ 0.030	2.530 2.470		
4	Wearshoe	6.000inches $\pm$ 0.010	6.010 5.990		
5	Wearshoe	12.104inches $\pm$ 0.010	12.114 12.094		
6	Wearshoe	18.000inches $\pm$ 0.010	18.010 17.990		
7	Wearshoe	18.000inches $\pm$ 0.010	18.010 17.990		
8	Wearshoe	18.000inches $\pm$ 0.030	18.030 17.970		
9	Wearshoe	9.000inches $\pm$ 0.030	9.030 8.970		
10	Wearshoe	11.500inches $\pm$ 0.030	11.530 11.470		
11	Wearshoe	0.300inches $\pm$ 0.010	0.310 0.290		
12	Wearshoe	0.300inches $\pm$ 0.010	0.310 0.290		
13	Wearshoe	0.188inches + 0.005 - 0.001	0.193 0.187		
14	Wearshoe	0.375inches $\pm$ 0.010	0.385 0.365		
15	Wearshoe	0.063inches $\pm$ 0.010	0.073 0.053		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S186896



Part: D3564-9

Job No: 194398

Serial No/Batch: S186896

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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